



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 178803



Part No: D350-591-311

Job Qty: 10 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/7/18

Job Tracking No:

Due Date: 7/20/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in born DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Large Fab-4		SLY
110	Large Fab	10 pcs	7/20/18	7/20/18	0.00	9.91	Large Fab 2		SLY
120	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC9		SLY 2018-06-26
130	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC5		SLY 2018-06-26
140	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.84	HandFinish1	DAS	BEB 18-07-02
150	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC7-2	← 24	
180	Large Fab	10 pcs	7/20/18	7/20/18	0.00	9.91	Large Fab 2	9-89	SLY
190	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC10		CPC
200	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC5		CPC
210	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.84	HandFinish1		SA 18-07-11
220	Powdercoat	10 pcs	7/20/18	7/20/18	0.00	2.90	Powdercoat1		BLK 18-7-12
230	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.84	HandFinish3		BEB 18-07-12
240	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC3		38
250	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-3		JUL 18 2018
260	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC4		28
270	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		9-89
275	DC	10 pcs	7/20/18	7/20/18	0.00	0.00	DC		21 JUL 18 2018
280	QC21-FG	10 Ea	7/20/18	7/20/18	0.00	0.00	QC21		9-89

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M134785 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod M134785 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 10:55 OVEN TEMPERATURE: 800 FINISH TIME: 11:25

270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

4327

wingwalk 5080995.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	S077589
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	S068282- S0704 26
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	S081396
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	S084685
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	S077435
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	S079116
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	
D2618	Bushing	20 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	256	0
	D3219-1	20	155	0
	D3272-1	10	10	0
180-Large Fab	D3065-041	10	32	0
	D3066-1	20	273	0
	MS20600-AD4W4	160	1,611	0
250-Packaging	AN3-35A	20	308	0
	AN4-13A	80	1,217	0
	AN5-36A	20	306	0
	D2230-3	40	20	0
	D2618	20	154	0
	D2856-400-720	20	60	0
	D3235-1	20	246	0
	D3278-041	10	46	0
	MS21042L3	20	1,903	0
	MS21042L4	80	2,976	0
	MS21042L5	20	659	0
	NAS1149D0363J	40	2,225	0
	NAS1149D0463J	160	5,149	0
	NAS1149D0563J	40	2,099	0

Part Specifications

Specifications could not be found.

1 # 3980
2 # 4208

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S082734



Part: D350-591-311

Job No: 178803

Serial No/Batch: S082734

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/20/18



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004327	S090796	AN3-35A	Bolt	S067891	ST348	20
004327	S090797	AN4-13A	Bolt	S067892	ST344	80
004327	S090798	AN5-36A	Bolt	S068656	ST336	20
004327	S090921	D2618	Bushing	S082275	ST008	20
004327	S090922	D2856-400-720	Abrasion Strip 4" X 7.20"	S079659	ST418	20
004327	S090926	D3235-1	Mounting Lug	S069956	ST522	20
004327	S090925	D3278-041	Support Assembly	S083384	ST522	10
004327	S090821	MS21042L3	Nut	S078167	Cycle Retire	20
004327	S090819	MS21042L4	Nut	S062378	ST303	80
004327	S090813	MS21042L5	Nut	S058178	ST303	20
004327	S090804	NAS1149D0363J	Washer	S015269	ST263	40
004327	S090803	NAS1149D0463J	Washer	S062379	ST263	160
004327	S090802	NAS1149D0563J	Washer	S068662	ST263	40

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Large Fab-4		S.L.
110	Large Fab	10 pcs	7/20/18	7/20/18	0.00	9.91	Large Fab 2		S.L.
120	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC9		AM 2018 06 26
130	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC5		AM 2018 06 26
140	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.84	HandFinish1	DAS	BEB IF-07-02.
150	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC7-2	24	
180	Large Fab	10 pcs	7/20/18	7/20/18	0.00	9.91	Large Fab 2	9-89	S.L.
190	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC10		
200	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC5		
210	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.84	HandFinish1		
220	Powdercoat	10 pcs	7/20/18	7/20/18	0.00	2.90	Powdercoat1		
230	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.84	HandFinish3		
240	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC3		
250	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-3		JUL 11 2018
260	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC4		
270	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		
275	DC	10 pcs	7/20/18	7/20/18	0.00	0.00	DC		
280	QC21-FG	10 Ea	7/20/18	7/20/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 3-Grind End Plate flush
180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.
220 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084
275 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Job BOM				
Part / Item	Component Name	Quantity	Unit	Material
D3067-1	End Plate	20 Ea	(2 ea)	
D3219-1	Plate	20 Ea	(2 ea)	
D3272-1	Step	10 Ea	(1 ea)	
D3065-041	Step/Leg Assembly	10 Ea	(1 ea)	
D3066-1	Spacer	20 Ea	(2 ea)	
MS20600-AD4W4	Rivet	160 Ea	(16 ea)	
AN3-35A	Bolt	20 Ea	(2 ea)	5067891
AN4-13A	Bolt	80 Ea	(8 ea)	5067892
AN5-36A	Bolt	20 Ea	(2 ea)	5068656
D2230-3	Mounting Lug	40 Ea	(4 ea)	
D2618	Bushing	20 Ea	(2 ea)	5082275
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea	(2 ea)	5079659
D3235-1	Mounting Lug	20 Ea	(2 ea)	5069956
D3278-041	Support Assembly	10 Ea	(1 ea)	5083384
MS21042L3	Nut	20 Ea	(2 ea)	5078167
MS21042L4	Nut	80 Ea	(8 ea)	5062378
MS21042L5	Nut	20 Ea	(2 ea)	5058178
NAS1149D0363J	Washer	40 Ea	(4 ea)	5015209
NAS1149D0463J	Washer	160 Ea	(16 ea)	5062379
NAS1149D0563J	Washer	40 Ea	(4 ea)	5068662

Job Allocations				
Operation	Component Part	Quantity	Unit	Material
90-Start up Operation	D3067-1	20		
	D3219-1	20		
	D3272-1	10		
	D3065-041	10		
	D3066-1	20		
180-Large Fab	MS20600-AD4W4	160		
	AN3-35A	20		
	AN4-13A	80		
	AN5-36A	20		
	D2230-3	40		
250-Packaging	D2618	20		
	D2856-400-720	20		
	D3235-1	20		
	D3278-041	10		
	MS21042L3	20		
	MS21042L4	80		
	MS21042L5	20		
	NAS1149D0363J	40		
	NAS1149D0463J	160		
	NAS1149D0563J	40		

Part Specifications

Specifications could not be found.

204327

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4209



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004327	S090796	AN3-35A	Bolt	S067891	ST348	20
004327	S090797	AN4-13A	Bolt	S067892	ST344	80
004327	S090798	AN5-36A	Bolt	S068656	ST336	20
004327	S092828	D2230-3	Mounting Lug	s088979	ST521	40
004327	S090921	D2618	Bushing	s082275	ST008	20
004327	S090922	D2856-400-720	Abrasion Strip 4" X 7.20"	s079659	ST418	20
004327	S090926	D3235-1	Mounting Lug	s069956	ST522	20
004327	S090925	D3278-041	Support Assembly	s083384	ST522	10
004327	S090821	MS21042L3	Nut	S078167	Cycle Retire	20
004327	S090819	MS21042L4	Nut	S062378	ST303	80
004327	S090813	MS21042L5	Nut	S058178	ST303	20
004327	S090804	NAS1149D0363J	Washer	S015269	ST263	40
004327	S090803	NAS1149D0463J	Washer	S062379	ST263	160
004327	S090802	NAS1149D0563J	Washer	S068662	ST263	40

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.